

Date: Monday, 11/08/2008 10:17:16 AM  
 User: Melanie Fauteux

## Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE ASSEMBLY  
 Job Number : 05035  
 Estimate Number : 13488  
 P.O. Number :  
 This Issue : 11/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 21/07/2008 Type : R & D LG FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By : mf 08-08-11  
 Comment : Est Rev:A 08-07-21 new issue DD verified by:EC

Part Number : D3805041  
 Drawing Number : D3805 PROTO  
 Project Number : N/A  
 Drawing Revision : PROTO  
 Material :  
 Due Date : 28/07/2008 Qty: 2 Um: Each

## Additional Product

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 D38051 Fwd Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Fwd Plate

batch: 341005

lpc 08-08-12

2.0 D38053 Aft Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Aft Plate

batch: 305036

lpc 08-08-12

3.0 D38061 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bar

batch: 340675

lpc 08-08-12

4.0 D38063 Bar



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bar

batch: 340676

lpc 08 08 12

5.0 D38065 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bar

batch: 340677

lpc 08 08 12

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 05035

Part Number: D3805041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D38067

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch:

B40678

CP 08-08-12

7.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Clamp(per MIL-DTL-8783C)

batch:

N/A

CP 08-08-12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld D3805-1 fwd plate to D3805-3 aft plate as per dwg D3805

2- position clamps to plates and weld as per dwg D3805 (install clamps on outside surface except where indicated on dwg)

3- position D3806-1, -3, -5 and -7 bars to plates and weld as per dwg D3805 (SEE NOTE 9)

304 S.S. Welding Rod

BATCH #:

M106762

4- weld hardcoat, 0.188" thick X 0.500 wide, flush with D3806-X bars as per dwg D3805 (SEE NOTE 10)

7560 Hardcoat Welding Rod

BATCH #:

M108631

CP 08-08-13

(X1)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CONCEPTUAL  
PLUTO ONLY

N/A

ENGINEERING  
APPROVAL

CP 08-08-13

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

CP 08-08-13

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

N/A

CP 08-09-26

Date: Monday, 11/08/2008 10:17:16 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 05035

Part Number: D3805041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



CP 08.04.25

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



ENG USE



Comment: PACKAGING RESOURCE #1

Identify and Stock

FOR ENGINEERING USE ONLY

Location: \_\_\_\_\_

ONLY

N/A

CP 08.09.25

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00255A

u 8.9.25

**PARTS LIST**

QTY.	PART NUMBER	DESCRIPTION
X	D3805-041	WEARPLATE ASSEMBLY
1	D3805-1	FWD PLATE
1	D3805-3	AFT PLATE
1	D3806-1	BAR
2	D3806-3	BAR
1	D3806-5	BAR
1	D3806-7	BAR
1	D3807-1	GASKET

**PROTOTYPE**  
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08.08.11

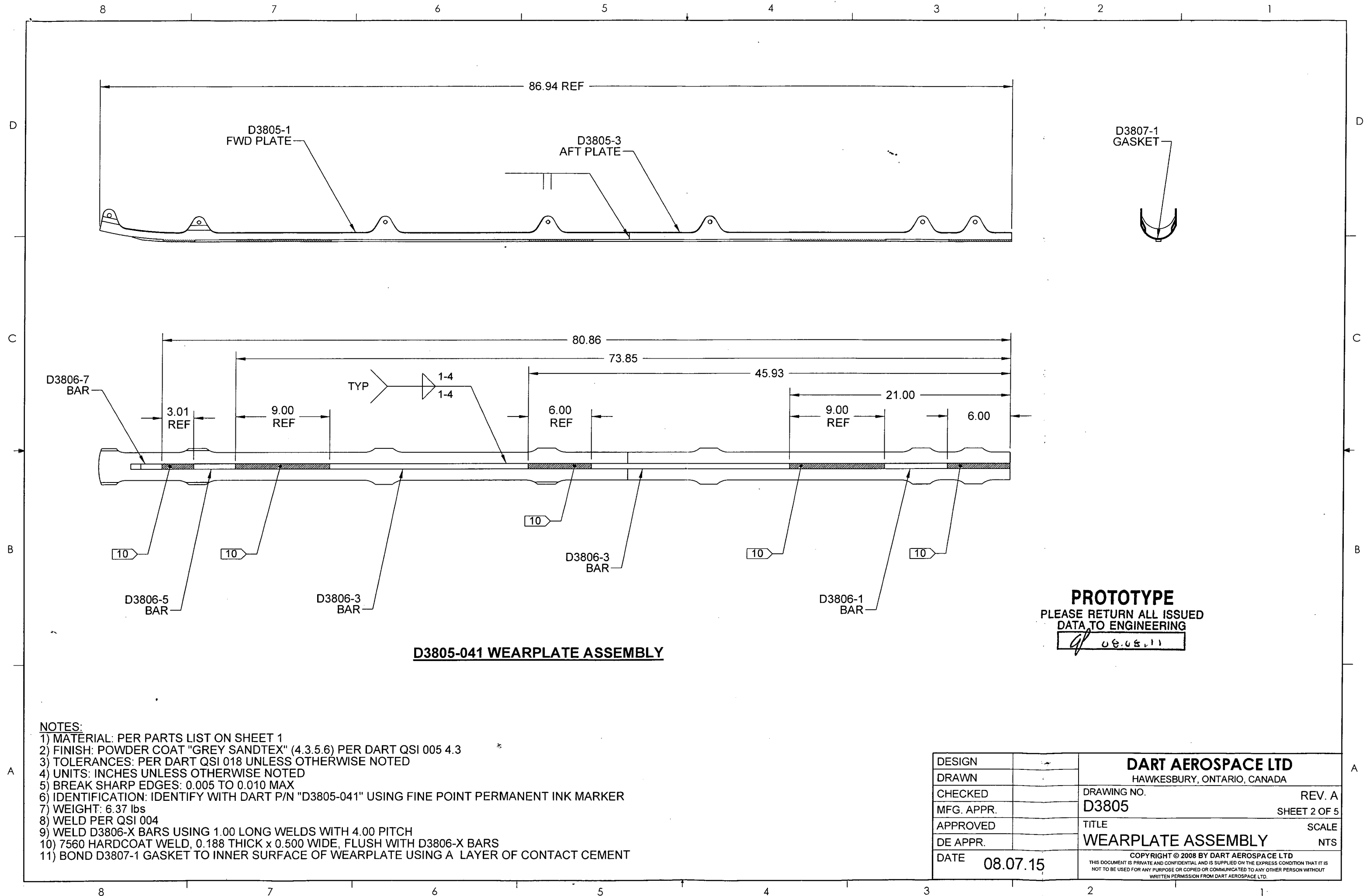
D3807-1 GASKET, REF

D3805-1 FWD PLATE, REF

D3805-3 AFT PLATE, REF

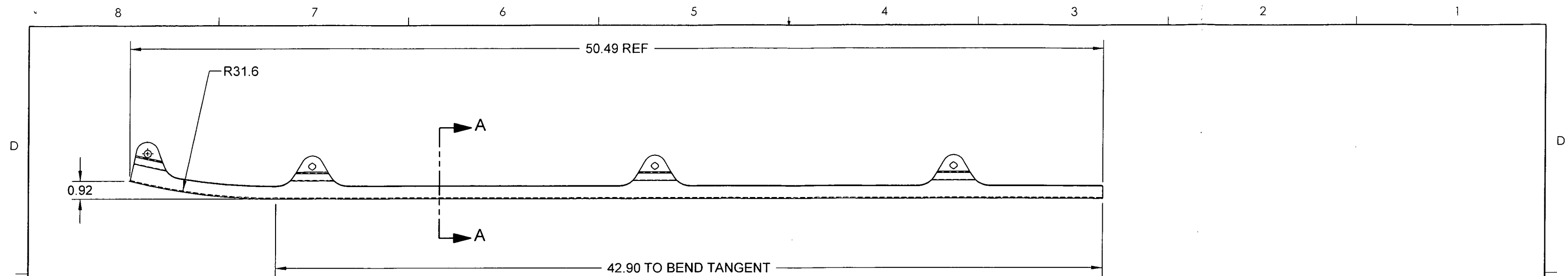
**D3805-041 WEARPLATE ASSEMBLY**

A	NEW ISSUE	CP	08.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

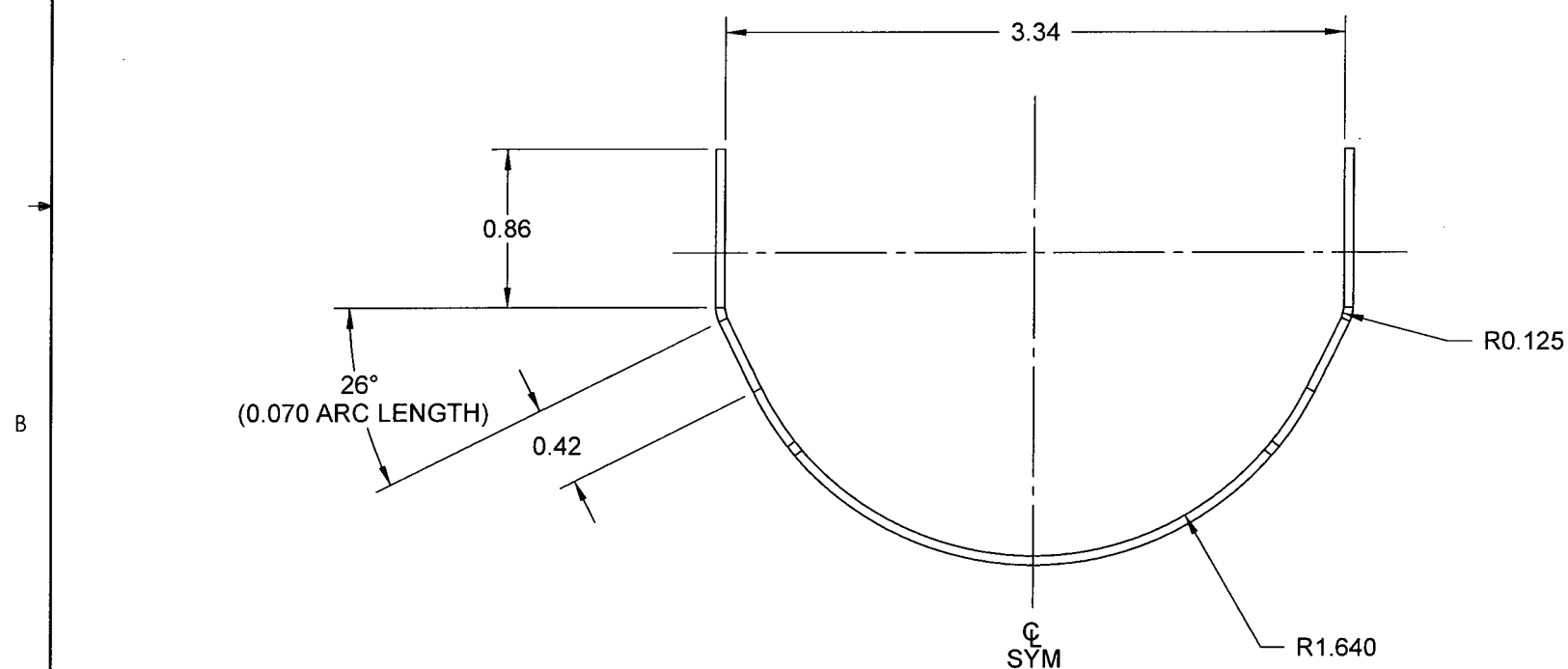


- NOTES:
- 1) MATERIAL: PER PARTS LIST ON SHEET 1
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 6.37 lbs
  - 8) WELD PER QSI 004
  - 9) WELD D3806-X BARS USING 1.00 LONG WELDS WITH 4.00 PITCH
  - 10) 7560 HARDCOAT WELD, 0.188 THICK x 0.500 WIDE, FLUSH WITH D3806-X BARS
  - 11) BOND D3807-1 GASKET TO INNER SURFACE OF WEARPLATE USING A LAYER OF CONTACT CEMENT

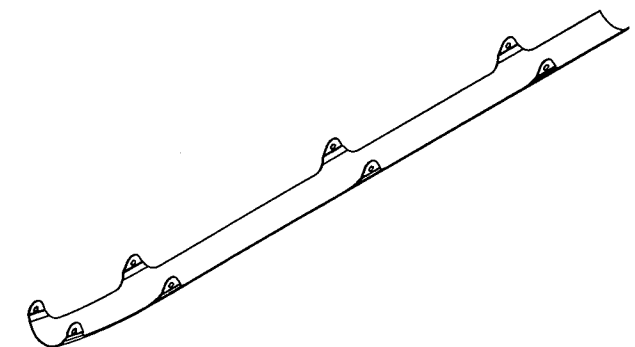
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DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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**D3805-1 FWD PLATE**



**SECTION A-A  
SCALE 5X**



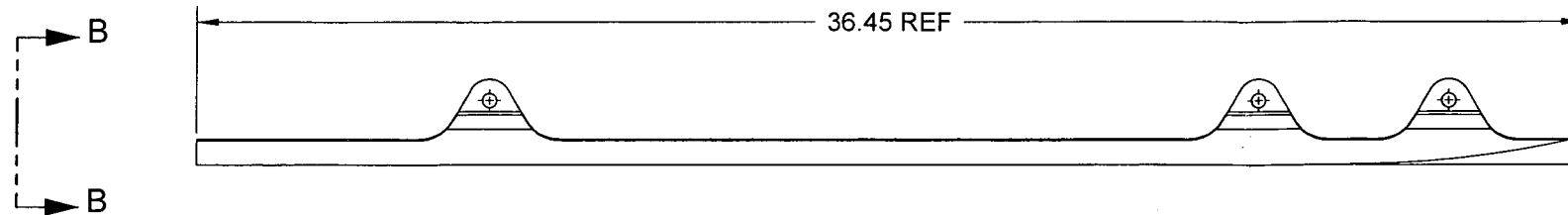
**PROTOTYPE**  
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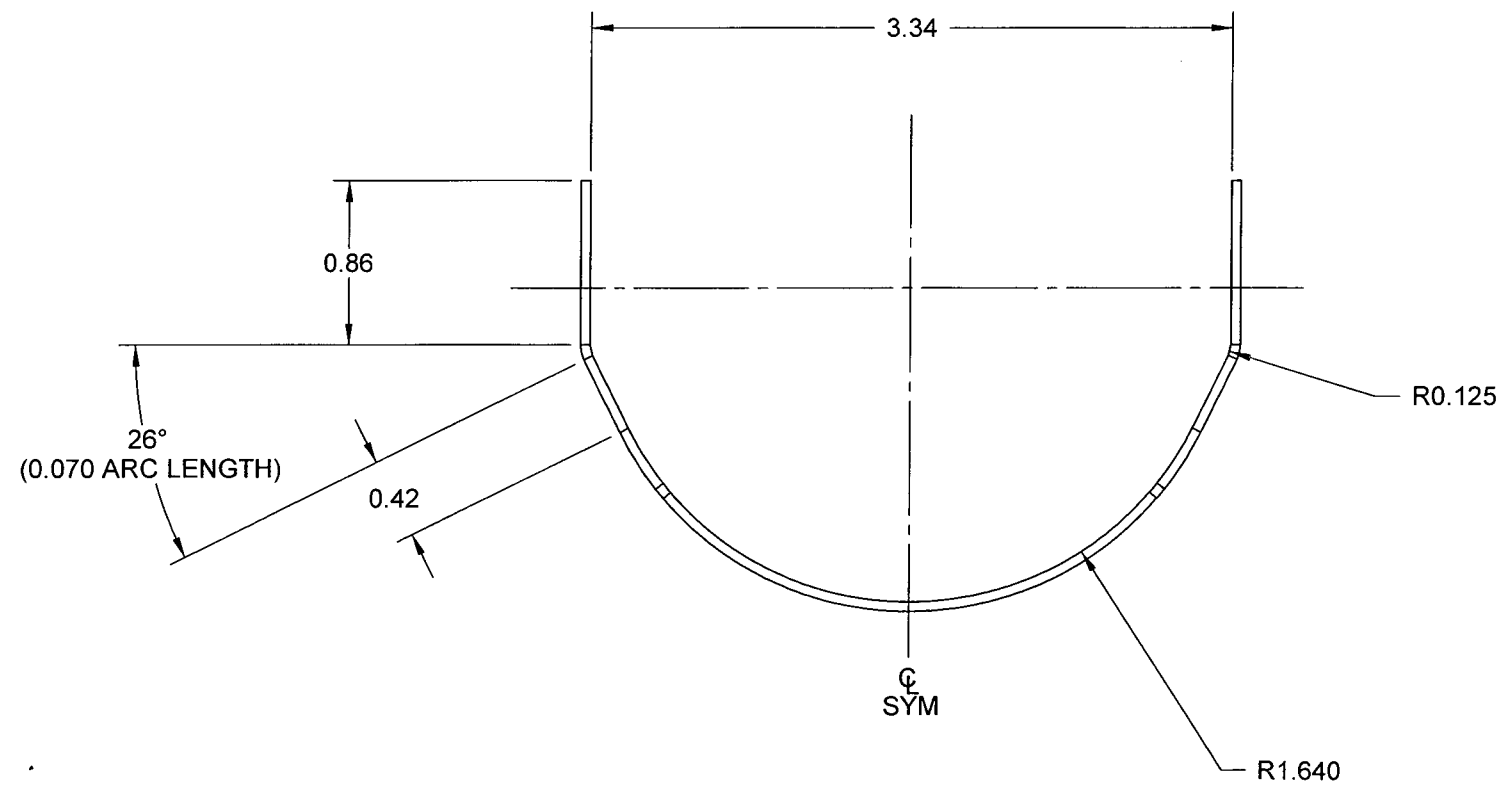
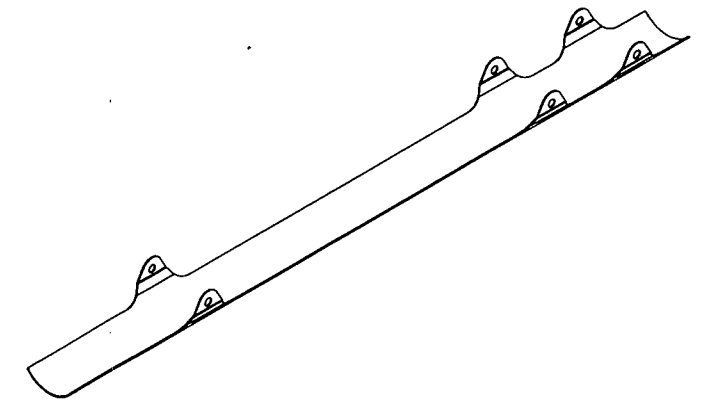
**NOTES:**

- 1) MATERIAL: MAKE FROM D3805-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

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MFG. APPR.		<b>D3805</b>	SHEET 3 OF 5
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**D3805-3 AFT PLATE**

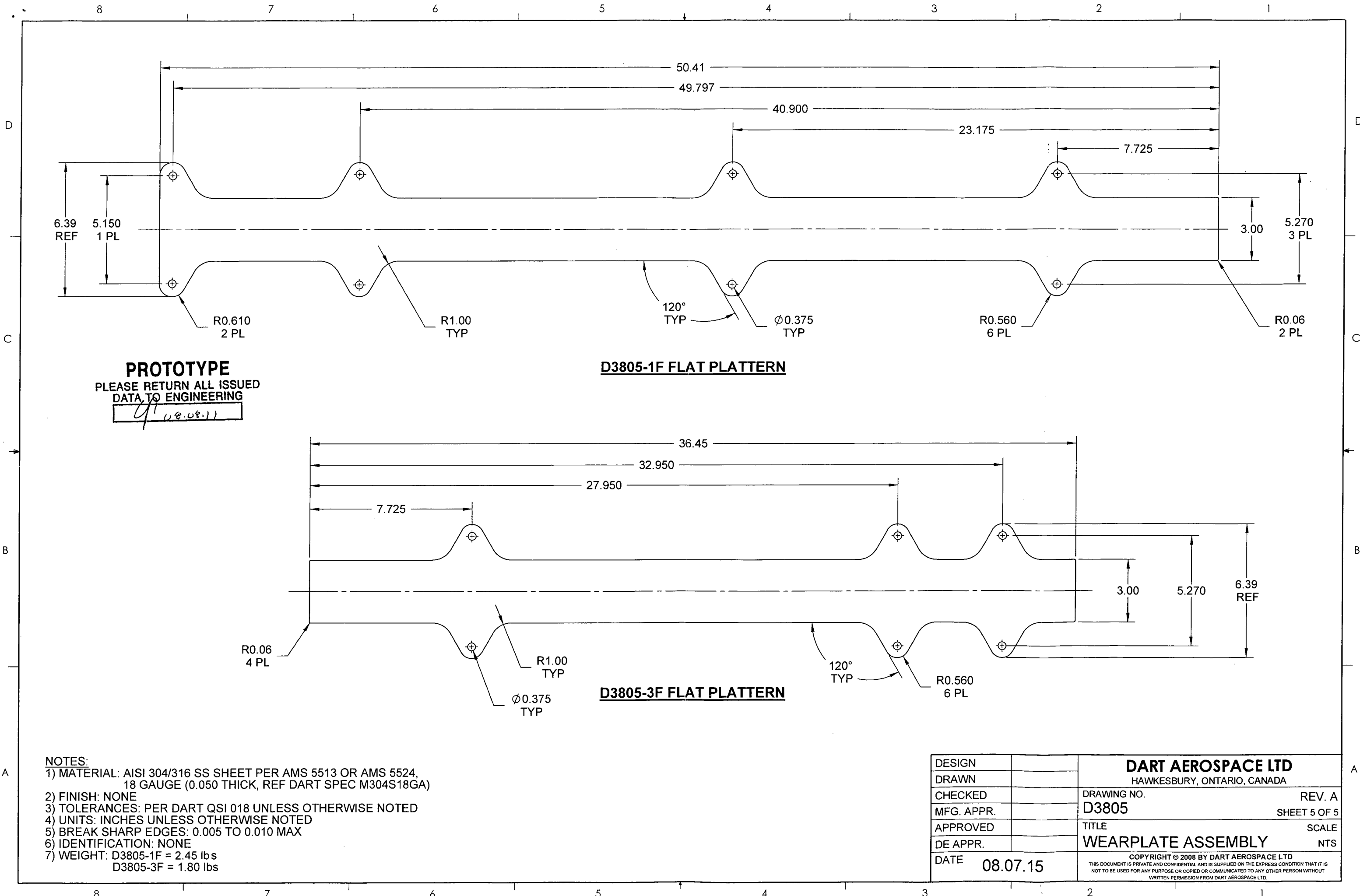


**VIEW B-B  
SCALE 5X**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
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*08.08.11*

- NOTES:**
- 1) MATERIAL: MAKE FROM D3805-3F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.80 lbs

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APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSEMBLY</b>	NTS
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*[Signature]* (U.S. 08.07.15)

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK, REF DART SPEC M304S18GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: D3805-1F = 2.45 lbs  
D3805-3F = 1.80 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3805</b>	SHEET 5 OF 5
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